

# Work Order ID 67364

Wednesday, March 16, 2011 12:55:59 PM

Page 1

Item ID: D3043-041

Accept

Revision ID:

Item Name: Step Weldment LH, A119

Start Date: 3/17/2011 Start Qty: 4.00

Required Date: 3/29/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MF Date: 11-03-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3043	Rev A
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100



Large Fab

Large Fab

0.00

Memo

0.00

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G  
2-Deburr and bevel ends for welding

11-04-06 4 0

110



QC

Quality Control

QC  
QC - Inspect part completeness to step on W/O

0.00

Memo

0.00

11-04-12

120



Large Fab

Large Fab

0.00

Memo

0.00

1-Weld 1 End Cap & Mounting Lugs as per QS1 004 & Dwg D3043 Using DT8802  
AR AL ROD Batch: 114703  
2-Grind Fwd End Cap weld flush 115928

11-04-14 4 0

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BEN/04/26

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SIN/04/26



150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

x4 HA 6 AL 11/05/02

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Large Fab

Large Fab

Large Fab

Memo

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043  
AR AL ROD Batch: M114703  
2-Inspect for foreign object as per QSI 024  
3-Grind Fwd End Cap weld flush

0.00

0.00

*11.05.04*

*4*

*Ø*

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

*Silvers*

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*Silvers*

*(X4)*  
*LH*

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Stop



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Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

=> m-l 11/05/05

4LH

200

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> m-l 11/05/05

4LH

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40  
320 OF  
9:10

4LH & m-l 11/05/07

M116964

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Wing Walk as per dwg QSI005 4.4 Batch	117300							
	HandFinish	Memo							
	Hand Finishing								
230	QC3- Inspect Part Finish	0.00							
	QC	Memo							
	Quality Control								
240	Identify as per dwg & Stock Location: _____	0.00							
	Packaging	Memo							
	Packaging								

x4 LH of 24 11/05/09

H BK 11-5-9

PP 67362

11/5/10 JF4

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Required Date: 3/29/2011 Req'd Qty: 4.00



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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

11/5/11

# Picklist Print

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Page 1

Work Order ID: 67364

Parent Item: D3043-041

Parent Item Name: Step Weldment LH, A119

Start Date: 3/17/2011

Required Date: 3/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C



Step Extrusion

Manufactured

No

120

Each

39.5110

1

4



11.04.14

Location

Loc Qty

Loc Code

WA

39.511

55214

1.92

58544

1

61208

4.724

64409

31.867

D2734



Step End Plate

Manufactured

No

120

Each

76.0000

2

8



11.04.14

Location

Loc Qty

Loc Code

WA015

76

62931

1

66143

75

D3040-1



Mounting Lug

Manufactured

No

120

Each

38.0000

2

8



11.04.14

Location

Loc Qty

Loc Code

WA018

38

48239

38

D3040-3



Mounting Lug

Manufactured

No

100

Each

34.0000

2

8



11.04.14

Location

Loc Qty

Loc Code

WA018

34

48240

34



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE NTS
A	01.06.28	NEW ISSUE	

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

**NOTES:**

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP  
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
01.07.05 *[Signature]*

*#67364*

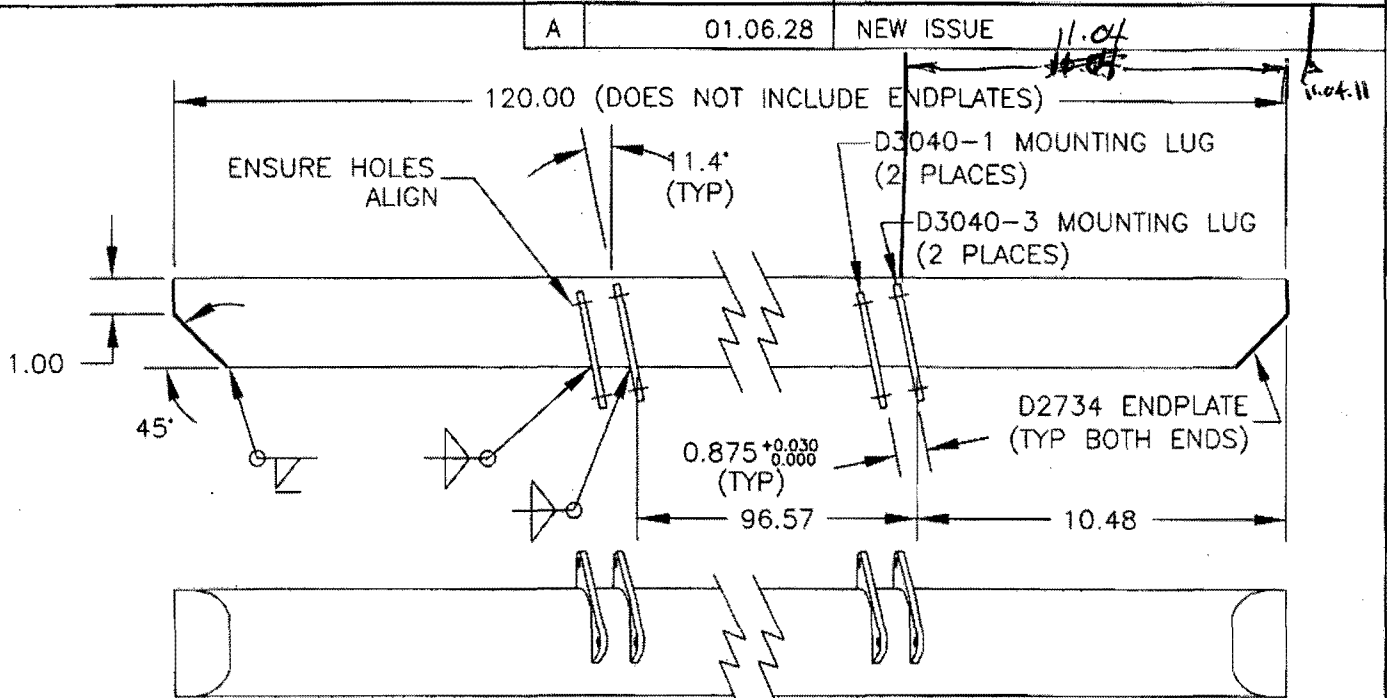
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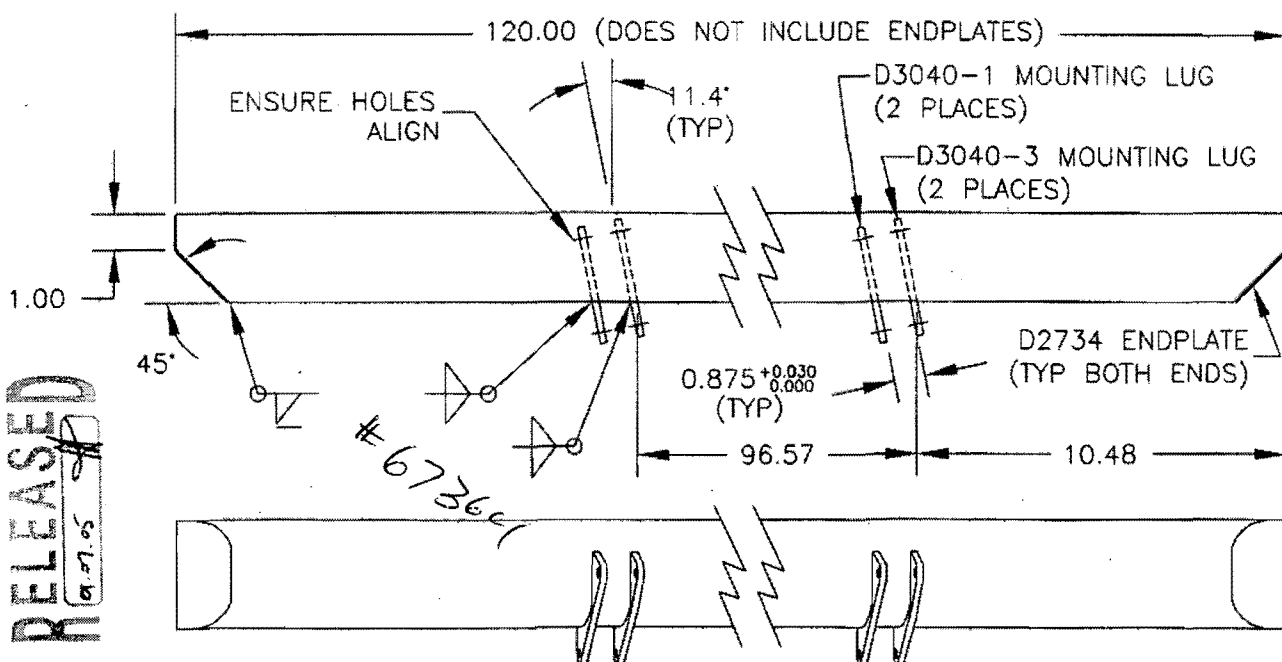


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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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